

Work Order ID 86147

86147

Page 1

June-21-12 8:39:45 AM

Item ID: D4110-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Door Doubler, LH

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4110	A

100		0.00
-----	--	------

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

304,063

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Memo

0.00

Quality Control

B12-7-5

B12-7-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5/21/10		(410)			
130 *130* Small Fab Small Fab	Memo 1- C'sink holes as per dwg	0.00 0.00				10X			5/21/10
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/21/10		(410)			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>94</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

(16x)

12-7-11 SD

OK 12/7/12

11207-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:39:49 AM

Page 1

Work Order ID: 86147

86147

Parent Item: D4110-1

D4110-1

Parent Item Name: Door Doubler, LH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	2.5746	0.0318	0.200842	c 5		

M304S16GA

304/316 Sheet .063

**

1812-7-5

Location

Loc Qty

Loc Code

MAT020

2.574633

121889

2.574633

122245

(10)

W/O:		WORK ORDER CHANGES					
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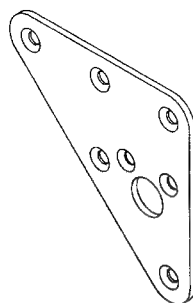
Dart Aerospace Ltd

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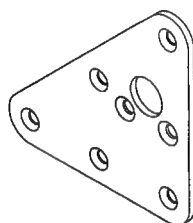
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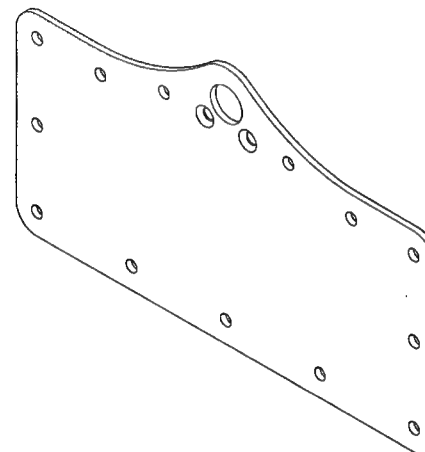
NOTE: Date & initial all entries



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR



D4110-3 DOUBLER, SILL

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 86147MCS
 12/06/21

RELEASED
 2010-09-23
 AND

A		NEW ISSUE		JPH		10.07.20	
REV.		DESCRIPTION		BY		DATE	
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	JPH					SHEET 1 OF 3	
CHECKED	JPH					SCALE	
MFG. APPR.	JPH					NTS	
APPROVED	JPH						
DE APPR.	JPH	D4110		TITLE			
DATE	10.07.20	DOUBLER					

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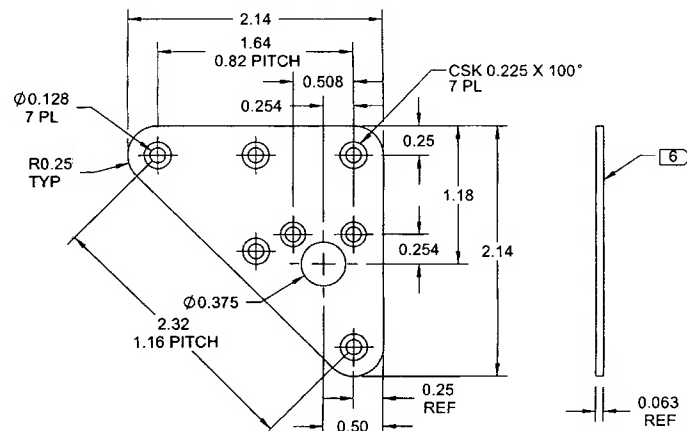
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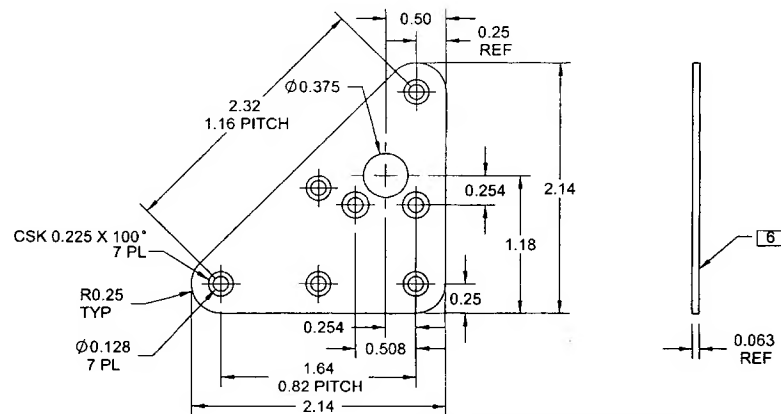
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NOTE: Date & initial all entries



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR

NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4110	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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2010-09-23

26147

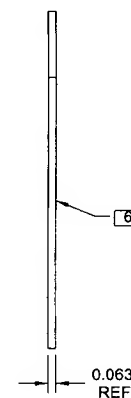
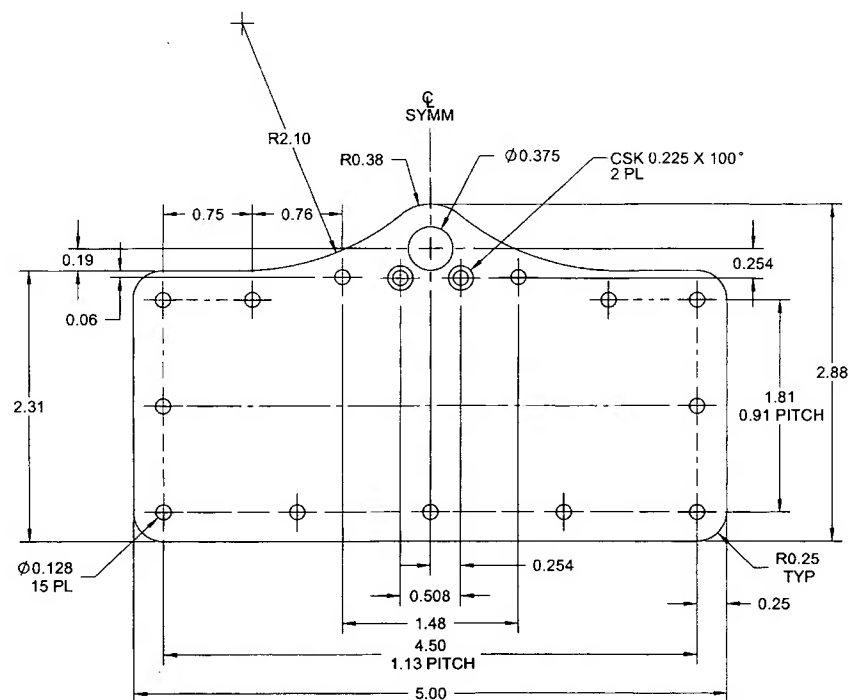
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D4110-3 DOUBLER, SILL

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.	JPH	SHEET 3 OF 3	
APPROVED	JPH	TITLE	SCALE
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